

Work Order ID 125480

October-09-14 7:33:55 AM

125480

Page 1

Item ID: D4131-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Base

Stop *NS2*

Start Date: 10/09/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/17/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4131

B

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

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Item ID: D4131-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Base
 Start Date: 10/09/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/17/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>(8)</u>			DAS 38 9-89 14-10-10
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00			DAS 30 9-89	<u>8</u>			14/10/14
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>(8)</u>	14-10-14		DAS 9 9-89

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Item ID: D4131-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Base

Stop ***NS2***

Start Date: 10/09/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/17/14 Req'd Qty: 6.00

6

Customer:

Reference:

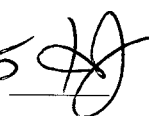
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____


Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>S1093</u>	0.00							
150									
Packaging	Memo	0.00				<u>8</u>	<u>2</u>	<u>14/10/14</u>	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

14/10/15 

 14-10-14

Picklist Print

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Page 1

Work Order ID: 125480

125480

Parent Item: D4131-3

D4131-3

Parent Item Name: Base

Start Date: 10/09/14

Required Date: 10/17/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

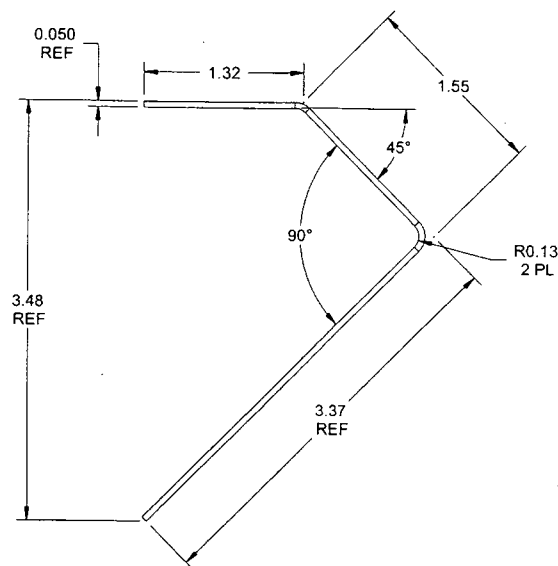
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	504.0120	0.1614	2			

M304S18GA

304/316 .050 Sheet

DC 14/10/09

Location	Loc Qty	Loc Code
MAT019	494.012	
117188	3	
117766	5	
120604	5	
122325	3	
123155	3	
124572	37.5	1.77
M126647	31.55	
M128254	51.412	
M128435	35.45	
M128864	14	
M129530	145.1	
M130345	160	
MAT020	10	
M126098	10	



D4131-3 BASE
MAKE FROM D4131-3F FLAT PATTERN

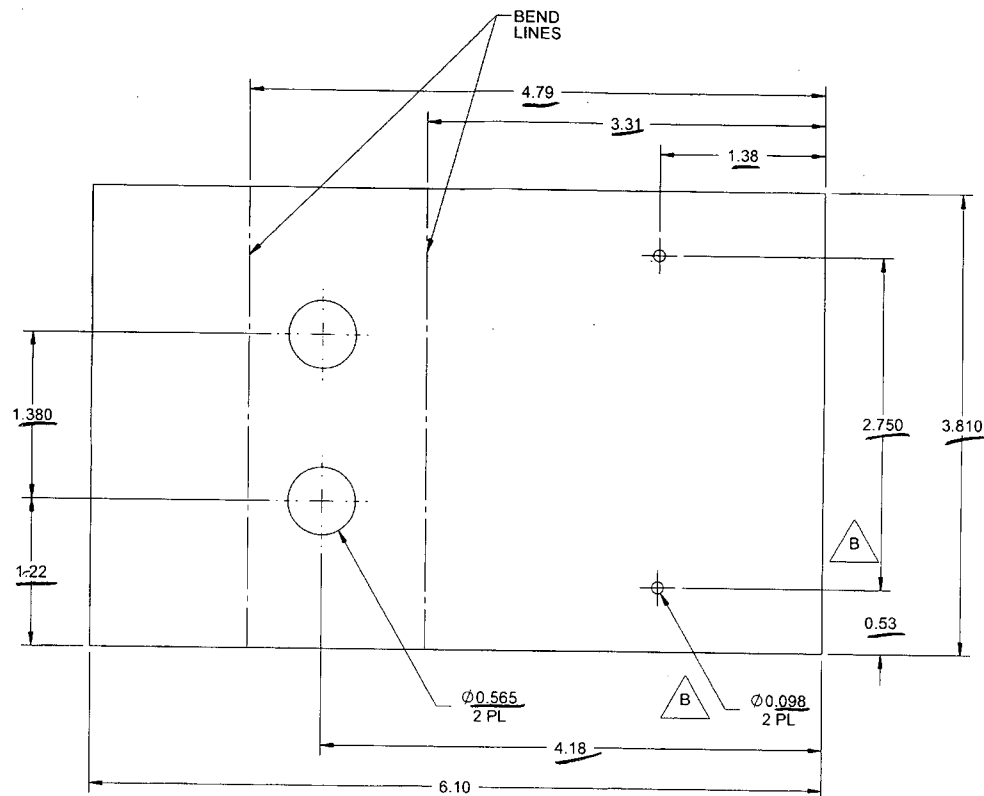
*WLO
125480*

RELEASED
2011-09-21

NOTES:

- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>WLO</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>WLO</i>	D4131	SHEET 6 OF 10
APPROVED	<i>WLO</i>	TITLE	SCALE
DE APPR.	<i>WLO</i>	MANIFOLD ASSEMBLY	NTS
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D4131-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>MD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D4131	SHEET 7 OF 10
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	MANIFOLD ASSEMBLY	NTS
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